

split w/o
SD 08/03/13Date: Monday, 7/9/2007 11:47:23 AM
User: Kim Johnston

Process Sheet

| | | | | | |
|-----------------------|-------------------------------------|-----------------------|------------------|-------------|---------|
| Customer | CU-DAR001 Dart Helicopters Services | | Drawing Name | STUD | |
| Job Number | 33369 -1 | | Part Number | D30281 | |
| Estimate Number | 10543 | | Drawing Number | D3028 REV A | |
| P.O. Number | | | Project Number | N/A | |
| This Issue | 7/9/2007 | S.O. No. : | Drawing Revision | A | |
| Prsht Rev. | NC | | Material | | |
| First Issue | / / | Type : MACHINED PARTS | Due Date | 7/30/2007 | Qty: 25 |
| Previous Run | 24630 | | Um: | Each | |
| Written By | John.07.09 | | | | |
| Checked & Approved By | | | | | |
| Comment | Est.B 02.09.10 Made on Cobra KJ | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : | |
|---------|-----------------------|---|---------------------|
| 1.0 | M4130NR0750 | 4130 steel rod .750" | |
| | | | |
| | | Comment: Qty.: 0.1313 f(s)/Unit Total : 3.9375 f(s) 4130 steel rod .750" Material: AISI 4130N Bar per MIL-S-6758 or AMS 6348/ 6370/ 6528 Ø0.750"(M4130N-R0.750) atch M104452 Threads per MIL-S-7742 | B |
| | | | 8. A 08/01/11 |
| 2.0 | HARDINGE | HARDINGE CNC LATHE SMALL | |
| | | | |
| | | Comment: BAND SAW HARDINGE 1-Turn blank per Dwg D3028 and FA263 2-Cut groove as per Dwg D3028 and FA263 3-Deburr and Tumble for a short time to prevent damage to threads | |
| | | | 8. A 08/01/11 |
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE | |
| | | | |
| | | Comment: INSPECT PARTS AS THEY COME OFF MACHINE | J.L / 8. A 08/01/11 |
| 4.0 | QC8 | SECOND CHECK | |
| | | | |
| | | Comment: SECOND CHECK | 7/10/08.02/18 30 |
| 5.0 | OUTSIDE SERV.30 | OUTSIDE SERVICES-MACH | |
| | | | |
| | | Comment: Sub-Contracting PURCHASING Issue P/O: 5683 Finish : Cadmium plate per QQ-P-416F Class 1, Type II Material release note is required. | 208/02/12 25 |
| | | | PTO |

| W/O: | | WORK ORDER CHANGES | | | | | |
|----------|------|----------------------------|----------|----------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 08.02.11 | 5 | tool 4 unplated for WAI | 08.02.11 | 08.02.11 | 4 | 4 | |
| | | | | | | | |

Part No: D3628-1 PAR #: N/A Fault Category: Prod/Machined Parts NCR: Yes No DQA: D Date: 08/03/14
QA: N/C Closed: H Date: 08/03/14

| WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | | |
|----------------------------------|------|---|----------------------------------|--|-----------------|---------------------------|-----------------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 08.02.11 | 22 | one part scrap origin was wrong R.c Human error | CP 08.02.11 PV 08/04/12 | SCRAP & REPLACE no Replace Qty (6) | J.L 08/02/11 | 08.02.11 | CP 08.02.11 PER 08/04/12 | 08/02.11 |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STUD

Job Number: 33369

Part Number: D30281

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage
Ensure Material Release Note is attached
Identify and Stock
Location: ST60

1/8/13

AS 08/03/13

25

7.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

1/8/08/13/14

25

Job Completion



2008/3/14

25

→ 6.1 QC 6 5/08/03/13 +25

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

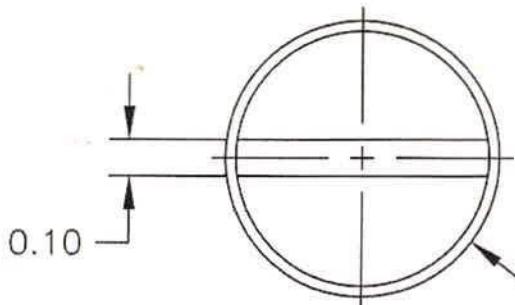
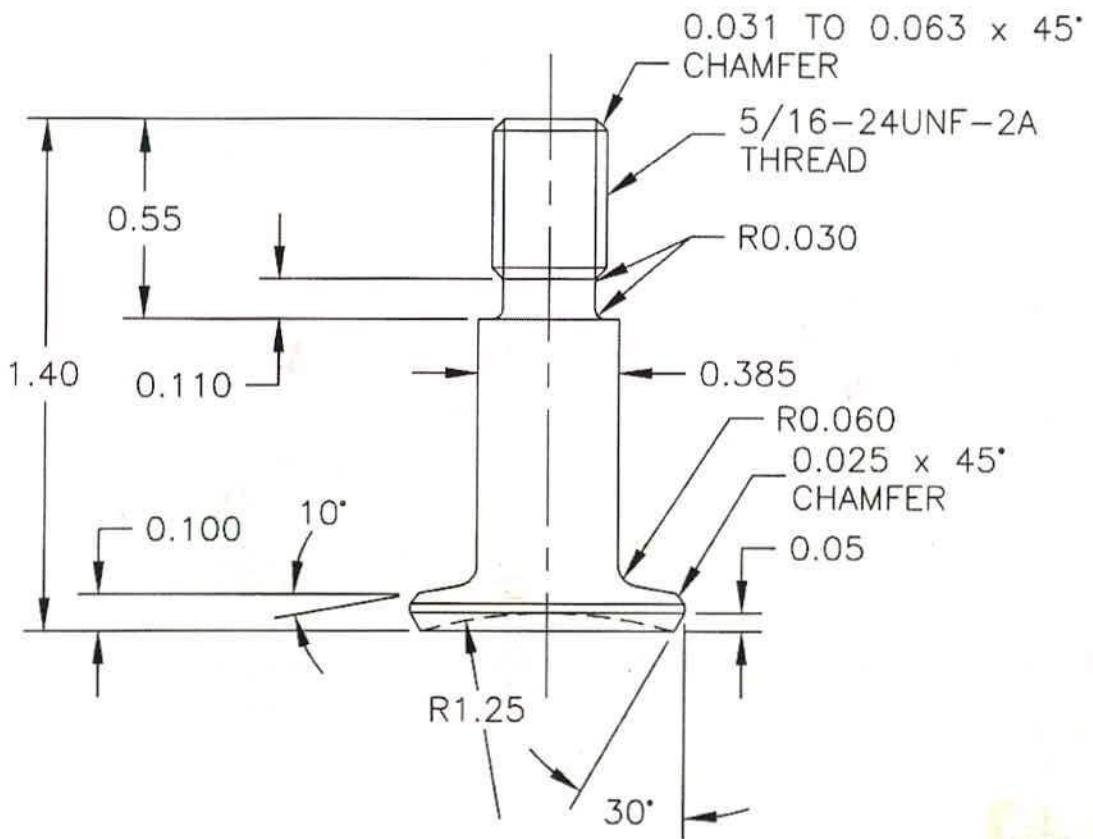
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | | |
|---------------------|-----------------------|---|--------------|--------------|
| DESIGN <i>CP</i> | DRAWN BY <i>CP</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | |
| CHECKED <i>✓</i> | APPROVED <i>✓</i> | DRAWING NO. D3028 | REV. A | SHEET 1 OF 1 |
| DATE 01.05.18 | | TITLE STUD | SCALE 2:1 | |
| A | 01.05.18 | NEW ISSUE | | |

SPECIFICATION CONTROL DRAWING



D3028-1:

- 1) POSSIBLE SUPPLIER: NORTHERN AERO INDUSTRIES P/N B83602-1
- 2) MATERIAL: AISI 4130N BAR PER MIL-S-6758 OR AMS 6348/6370/6528
- 3) THREADS PER MIL-S-7742
- 4) FINISH: CADMIUM PLATE PER QQ-P-416F CLASS 1, TYPE II
- 5) ALL DIMENSIONS ARE IN INCHES.
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY
RETURN TO
ENGINEERING
50-0.000
-0.015
REJECT TO AMENDMENT

NO. RELEASER
9-05-30 CH

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| | | |
|------------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 33369 |
| Description: STUD | Part Number: | D30281 |
| Inspection Dwg: D3028 Rev: A | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

8F

| | | | | | |
|--------------|---------------------------|-------------|-----------------|---------------------|--|
| Measured by: | <u>J. A / S.G. / J.L.</u> | Audited by: | <u>S. J.</u> | Prototype Approval: | |
| Date: | <u>08/01/11</u> | Date: | <u>08/02/09</u> | Date: | |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/RF | |



**Placage
Manco Domplex
Electroplating**

Siège social / Head Office Plan 1
4660 Hickmore 4670 Hickmore
Ville St-Laurent, Québec Ville St-Laurent, Québec
H4T 1K2 Fax: 514-355-5991
Fax: 514-355-8750

Plan 2
8001 Larrey
Anjou, Québec
Fax: 514-354-2937

**BON DE LIVRAISON
PACKING SLIP**

Tél.: 514-355-7867 / 1-877-355-7867

V
S
O
N
D
U
T
À
Dart Aerospace LTD
X
S
P
É
D
I
E
T
O
À
Dart Aerospace (710)
1270 Alexander St
Hawkesbury ONT K6A 1L1

**AUCUNE RÉCLAMATION APRÈS 5 JOURS DE LA DATE DE LIVRAISON
NO CLAIMS AFTER 5 DAYS FROM DATE OF DELIVERY**

BON DE LIVRAISON
109405

MANCO
DOMPLEX

8895 Crescent 3
Anjou (Québec) H1J 1B6
Tél.: (514) 355-7867
Fax: (514) 355-8750

ATN: CHANTAL - 1613-632 1053

CERTIFICAT DE CONFORMITÉ
CERTIFICATE OF COMPLIANCE

#424

Dalt Aerospace Ltd

Client / Customer

105683

Votre # de commande / Your purchase order #

1 lot of pieces

de la pièce / part

109405

Notre # de bon de livraison / Our packing slip #

| | | |
|--|-------------------------------|---|
| Inspecteur / Inspector | Date, équipe / Date, shift | |
| <i>Lenvault</i> | <i>Feb 28, 2008</i> | |
| Placage / Plating | <i>QDF 416 E C11 T-1/2 IT</i> | |
| Quantité totale / Total quantity | <i>1 lot</i> | Quantité inspectée / Inspected quantity |
| Adhésion / Adhesion | <i>Good</i> | |
| Épaisseur / Thickness | L.C.D | H.C.D |
| | | Moy. / aver. |
| Coulisses, taches / Leach, spots | <i>N/A</i> | Rugosité / Roughness |
| Quantité approuvée / Approved quantity | <i>1 lot</i> | Quantité rejetée / Rejected quantity |
| Commentaires / Comments | | |

D2968-041 B33099 = 505

D3028-1 B33369 = 250-5

Nous certifions que les pièces énumérées ci-dessus ont été faites en conformité avec vos dessins et spécifications et rencontrent les exigences contenues dans ces dessins et/ou spécifications.

We hereby certify that the parts listed above have been made in accordance with your drawings and specifications and are correct to the requirements contained in those drawings and/or specifications.

Signé au nom de
Signed on behalf of

MANCO
DOMPLEX